

Ship 12 June

Work Order ID 161200

161200

Page 1

Monday, May 08, 2017 10:23:27 AM

Item ID: D206-628-026BL Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Flight Step R/H For Mid Gear (Ael Blue)

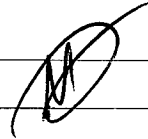
Start Date: 5/30/2017 Start Qty: 8.00 *8*

Required Date: 6/9/2017 Req'd Qty: 8.00 *8*

Reference: SCHEDULED/C

Cust Item ID:

Customer:

Approvals: Process Plan:  Date: MAY 08 2017 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4308	A
IIN-D206-628	G

100

Document Control

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

0.00

DAS
6
9-89

MAY 15 2017

8
DAS
27
9-89
JUN 28 2017

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

8
DAS
6
9-89
MAY 30 2017
DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																										
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Monday, May 08, 2017 10:23:27 AM

161200

***D206-628-026B1 ***

Required Qty: 8.00

IPP REV:A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4308-042Bb		Manufactured	No			110	Each	0.0000	1	8			
*D4308-042RI * Step, RH Crew DAS 27 9-89													
D2731-7RG		Manufactured	No			110	Each	12.0000	2	16			
D2731-7RG Mounting Lug DAS 27 9-89													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST532				12					
				150806				2					
				159234				10					
D3394-3RG		Manufactured	No			110	Each	6.0000	2	16			
D3394-3RG Lug DAS 27 9-89													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST532				6					
				140887				6					
D4309-1		Manufactured	No			110	Each	32.0000	2	16			
D4309-1 Bushing DAS 27 9-89													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				32					
				151106				2					
				159732				30					

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐							
Misidentified ☐	☐	Past Due ☐	OTHER : _____						

Picklist Print

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Page 2

Work Order ID: 161200

161200

Parent Item: D206-628-026BL

***D206-628-026BL ***

Parent Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 5/30/2017

Required Date: 6/9/2017

Start Qty: 8.00

Required Qty: 8.00

AN4-11A Purchased No 110 Each 45.0000 4 32

AN4-11A

BOLT

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	20	
120731	20	
ST344	25	
M136983	2	
M137166	23	

DAS
6
9-89
137495
JUN 02 2017
AS
28
9-89

AN4-12A Purchased No 110 Each 177.0000 4 32

AN4-12A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	10	
120423	10	
over003	125	
m137412	125	
ST344	42	
m136579	42	

DAS
6
9-89
JUN 02 2017
DAS
28
9-89

AN4-15A Purchased No 110 Each 198.0000 2 16

AN4-15A

Bolt

DAS
27
9-89

Location	Loc Qty	Loc Code
GA	10	
120449	10	
ST343	188	
m108868	24	
m132317	8	
m134606	8	
m137280	148	

DAS
6
9-89
JUN 02 2017
DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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161200

***D206-628-026B1 ***

Required Date: 6/9/2017

Required Qty: 8.00

110	Each	2.0000	16	48
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DA
6
9-89

JUN 02 2017

**AS
28**

Loc Code

2

2

110	Each	4,282.000	6	48
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DAS
6
-89

JUN 02 2017

DAS
28
29

Loc Code

48

48

4000

2000

2000

234

234

**DAS
27
9-88**

48

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 161200

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161200

Page 1

Item ID: D206-628-026BL Accept *N9000040100* Setup Start *NS1*

Revision ID: *NS2*

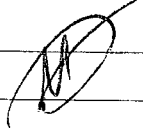
Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 5/30/2017 Start Qty: 8.00 *8*

Required Date: 6/9/2017 Req'd Qty: 8.00 *8*

Reference: SCHEDULED/C Cust Item ID:

Customer:

Approvals: Process Plan:  Date: MAY 08 2017 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4308	A								
IIN-D206-628	G								
100	Document Control	0.00							

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

  MAY 16 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging



Department of Transport

Supplemental Type Certificate

This approval is issued to:

DART Aerospace USA, Inc.
Fairchild International Airport
Building 1402-F
Port Angeles, WA 98363

Number: SH98-14**Issue No.:** 2**Approval Date:** May 11, 1998**Issue Date:** January 21, 1999**Responsible Office:**

Pacific

Aircraft/Engine Type or Model:

Bell 206A, 206B, 206L, 206L-1, 206L-3, 206L-4 and 407

Canadian Type Certificate or Equivalent:

H-92

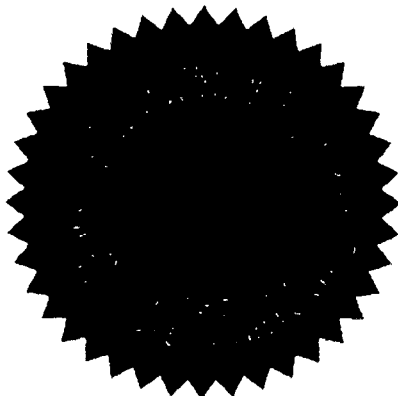
Description of Type Design Change:

Installation of DART Heli-Access-Steps on the Landing Gear
Cross Tubes in accordance with FAA STC SA00500SE

Installation/Operating Data,**Required Equipment and Limitations:**

These passenger steps are to be fabricated in accordance with DART Aerospace Master Drawing List (MDL) No. MDL-D206-628, Revision "A", dated December 10, 1997 and installed in accordance with DART Aerospace Installation Instruction No. IIN-D206-628, Revision "A", dated November 28, 1997. These passenger access steps must be maintained in accordance with DART Aerospace Maintenance Manual Supplement No. MMS-D206-628, Revision "A", dated November 27, 1997.

Basis of Certification as defined in the applicable Type Certificate Data Sheets.



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.

J. H. Nehera
Regional Manager, Aircraft Certification
For Minister of Transport

Canada

5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

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Revision: **G**
Date: 11.02.25